

Work Order ID 158412

Wednesday, March 22, 2017 10:49:13 AM

158412

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Item ID: D5021-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Foam, Center Panel, Aft
Start Date: 3/22/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/23/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED
Approvals: Process Plan: DAS 21 9-89 Date: MAR 22 2017 Run Start ***NR1***
QC: Date: Tooling: Date: Stop ***NR2***
SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5021	B								
100	FLOW WATER JET	0.06							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.02							
Quality Control									

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.01							
Packaging	*****STOCK IN BASKET CELL***** LOCATION WA004								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									



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Picklist Print

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Work Order ID: 158412

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Parent Item: D5021-5

D5021-5

Parent Item Name: Foam, Center Panel, Aft

Start Date: 3/22/2017

Required Date: 3/23/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM IPP
REV:B 14.04.09 NOW OUTSOURCE DD VERF:JLM IPP REV:C
17.02.21 NOW MADE IN HOUSE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5033-1		Manufactured	No			100	sf	205.0000	11	11.57895			
D5033-1									**				
Rigid Polyurethane Foam													

04/17/03/22

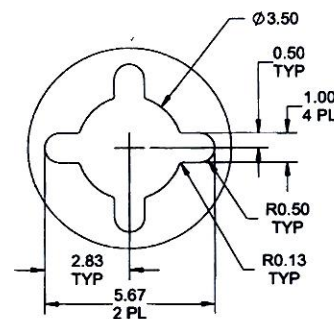
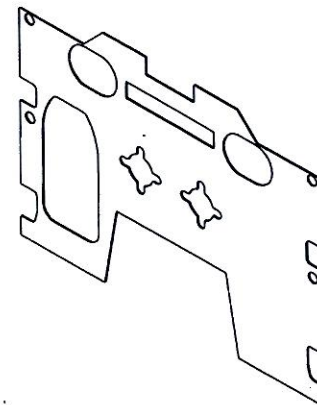
Location	Loc Qty	Loc Code
MAT019	20	
110489	20	
MAT020	185	
111972	67	
154887	118	

1.2

[illegible]

Engineering Approval: (if necessary)		Date:	
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~~H:\FORMS\Quality Assurance\approved QA\Inspection Sheet revB~~



RELEASE
2014-01-22

NOTES:

- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

D5021-1 FOAM, CENTER PANEL, FWD

B	ADDED DETAIL A (ZN B2-1, DS-1) & 1.81 (ZN B5-2, B5-3), 6.75 (ZN D6-2, B6-3); 3.04 (ZN B3-1, ZN B7-1); 2.30 WAS 1.64 & 1.51 (ZN B7-1, B7-2, B7-3); 1.70 WAS 1.83 (ZN B4-2); 9.90 WAS 9.78 (ZN B4-3); SOME DIMENSIONS SHIFTED DUE TO WIDTH CHANGE		RF	14.01.09
A	NEW ISSUE		RF	13.12.09
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>DL</i>	DRAWING NO.	REV.	
MFG. APPROV.	<i>DL</i>	D5021	SHEET 1 OF 1	
APPROVED	<i>DL</i>	TITLE	SCALE	SCALE
DE APPR.	<i>DL</i>	FOAM CORE	NT	NT
DATE	14.01.09			
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